

Work Order ID 71070

Tuesday, June 21, 2011 2:43:33 PM



Page 1

Item ID: D2646

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Cap

Start Date: 6/21/2011 Start Qty: 38.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 38.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/06/21 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2646

Rev C

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14338 ☐ 1-Spin as per Dwg D2646 ☐ 2-Material release note required

CL 11/06/21 (38)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

PC 11/1/11 (38)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Sular/07

counted
(438)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Drill using DT8026 as per Dwg D2646. □2-Open holes to .297 as per Dwg
D2646. □3-Deburr

9/5/07/12 (38)

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/4/07/12

w/notes
(+38)

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

38 BL 11-7-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71070

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Item ID: D2646

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Cap

Start Date: 6/21/2011 Start Qty: 38.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 38.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

Powder Coating

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

180



Small Fab

Small Fab

Small Fab

0.00

Memo

Install inserts as per Dwg D2646

38X ✓ M-11/07/13

38 ✓ M 6/21/21

38 ✓ M 6/21/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71070

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Item ID: D2646

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Cap

Start Date: 6/21/2011 Start Qty: 38.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 38.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

M 11 07 21 (3P)

200

Identify as per dwg & Stock Location: FP-4

0.00



Packaging

Memo

0.00

Packaging

38 0 11/10/21

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/17/21 MF
11-07-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71070



Parent Item: D2646

Parent Item Name: Aft Cap

Start Date: 6/21/2011

Required Date: 6/28/2011

Start Qty: 38.00

Required Qty: 38.00

Comments: IPP: G□05.08.22□Hole size revised in Step 5□KJ/JLM□
IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130 Insert		Purchased	No			110	Each	1,623.000	2	76		11/07/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST282		1623							
				117717		1623							
D2646P Aft Cap		Purchased	No			180	Each	0.0000	1	38		10/19/10	38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

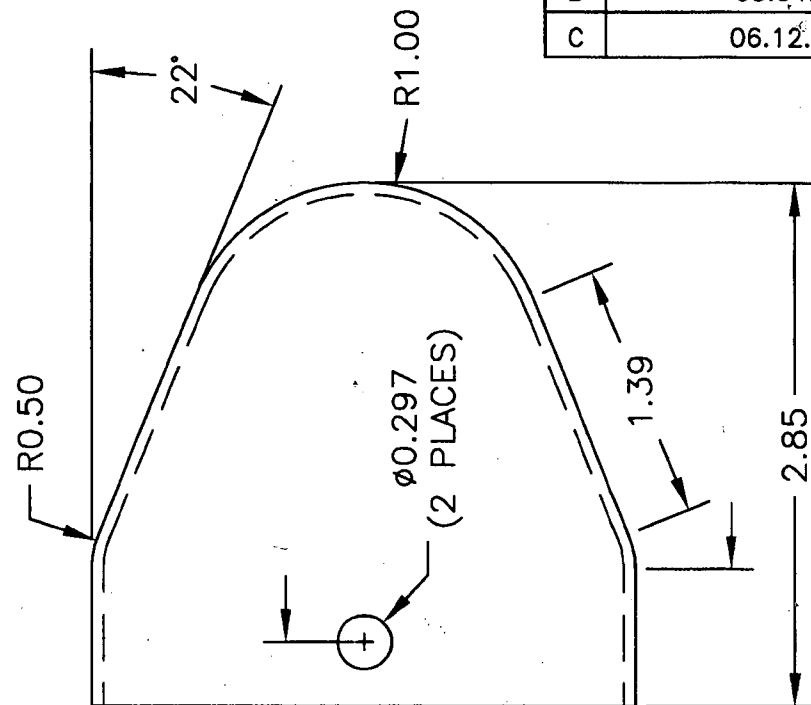
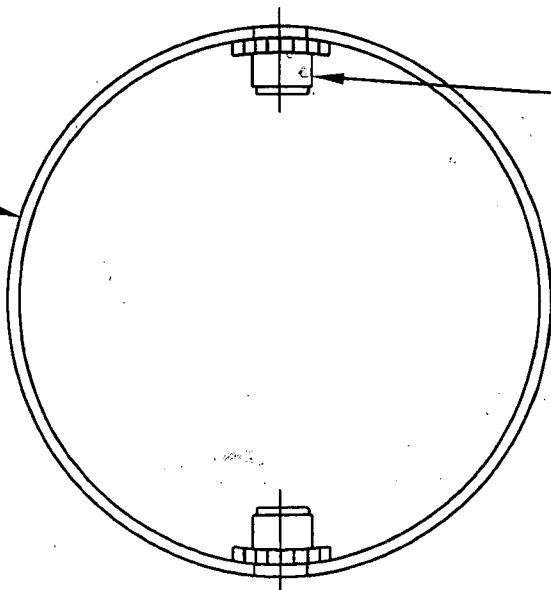
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS		DRAWN BY PH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2646	
DATE 06.12.20				REV. C SHEET 1 OF 1	
		TITLE AFT CAP		SCALE 1:1	
A	97.03.25		NEW ISSUE		
B	05.04.01		CHANGE TO CLOSED INSERTS		
C	06.12.20		CHANGE TO OPEN ENDED INSERTS		

 $\phi 2.980^{+0.000}_{-0.020}$ 

INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)

RELEASED

07.02.12

ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D2646 AFT CAP

- 1) MATERIAL:
- 2) FINISH:
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Sieg's Manufacturing Ltd. Packing Slip

Metal Spinning & Metal Fabricating

6236 205 Street

Langley, BC, Canada V2Y 1N7

Phone:(604)530 7455 Fax:(604)530-7490

Check out our website: www.siegsfmfg.com

Packing Slip No.:

39392

Date:

06/29/2011

Page:

1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 14338	Sold By: KAULBARS, ARLA
Shipped By:	Ship Date: 06/29/2011
Tracking No.:	

Item No.	Unit	Description	Quantity
D2646P	Each	Spin aft cap	50
Comment:			



Sieg's Manufacturing Ltd.

6236 205 Street Langley, B.C. Canada V2Y 1N7

Ph#: (604)530-7455 fax#: (604)530-7490

arla@siegsmfg.com

INSPECTION REPORT

Date: June 28, 2011

Customer: Dart Aerospace

Packing Slip: 39392

Part#:	Quantity	Material	Check holes	Insp. By.
D2646P	50	1100-0 (063)	N/A	<u>TO</u>

Notes:

Material Certification Attached: ✓



Alumax Mill Products, Inc.
(an Alcoa Inc. business)
1480 Manheim Pike
Lancaster, Pa. 17601

Certification of Test Results

SOLED TO

COPPER & BRASS SALES INC
22355 WEST ELEVEN MILE ROAD
SOUTHFIELD, MI 48034

SHIP TO

LEVELTEK
3236 STATE ROAD 39
PO BOX 148
LA PORTE, IN 46352

CERT NO 0001260979
DATE 12/13/2010
SKID NO 957160
SKID WGT 6,439
PAGE 1 OF 1

ORDER NO	LO0400	PO NO	5400080193-R01				MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO	ALFLR01226				
ALLOY	1100	TEMPER	O	FORM	COIL		
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000		

Alcoa Certification 0001260979

LOT: 461649 COIL: B01 DROP: 0P06534

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
0P06534	0.12	0.43	0.13	0.05	0.05	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 14.6 KSI
TAIL ULTIMATE STRENGTH 15.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 6.8 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.0 KSI
HEAD ELG IN 2 IN., AT FRACTURE 30 %
TAIL ELG IN 2 IN., AT FRACTURE 30 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-07
CHEMISTRY EXPRESSED AS % W/W FOR EACH REPORTED ELEMENT
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-10

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 O, ASTM B209-07 1100 O

** END OF CERTIFICATION **

ACCEPTABLE BASED ON SIMILARITY W/ OTHER "H" DRAWING, SPEC
CALLING ASTM B209 FOR SHEET METAL ALUMINUM.
(REF: H2024T3), H5052H32, H6061T6S).

12/08/07 QSLAR

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full. This material was melted in the United States or a qualifying country (REF DFARS 225.872.1A); It was manufactured in the United States.

These commodities, technology and software exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to U.S. law prohibited. This certification complies with EN 10204:2004.

Authorized By:

JEFF KREADY, LAB SUPERVISOR